

Work Order ID 131210

131210

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Item ID: D4799-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Clamp
 Start Date: 3/30/15 Start Qty: 32.00 ***32*** Cust Item ID:
 Required Date: 3/31/15 Req'd Qty: 32.00 ***32*** Customer:
 Reference:

Approvals: Process Plan: U Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D4799	C								
100		0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg Dwg Rev: <u>C</u> Prog Rev: <u>C</u> 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

32 Ø Im15-3-30
32 Ø Im15-3-30

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>st sp</u>	0.00				DAG 27 3-30			
150				32					
Packaging	Memo	0.00							
Packaging									
									APR 22 2015
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							MLJ 15-04-23
Quality Control									

APR 22 2015

MLJ 15-04-23

APR 22 2015

Picklist Print

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Work Order ID: 131210

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Parent Item: D4799-1

D4799-1

Parent Item Name: Clamp

Start Date: 3/30/15

Required Date: 3/31/15

Start Qty: 32.00

Required Qty: 32.00

Comments: IPP REV:A NEW ISSUE 13-03-28 JLM VERIFIED BY:DD IPP
REV:B AS PER REV C JLM 15.03.30 VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S14GA		Purchased	No				sf	170.0000		3			

M304S14GA

304SS sheet .080

Jm15.3.30

Location

Loc Qty

Loc Code

MAT019

170

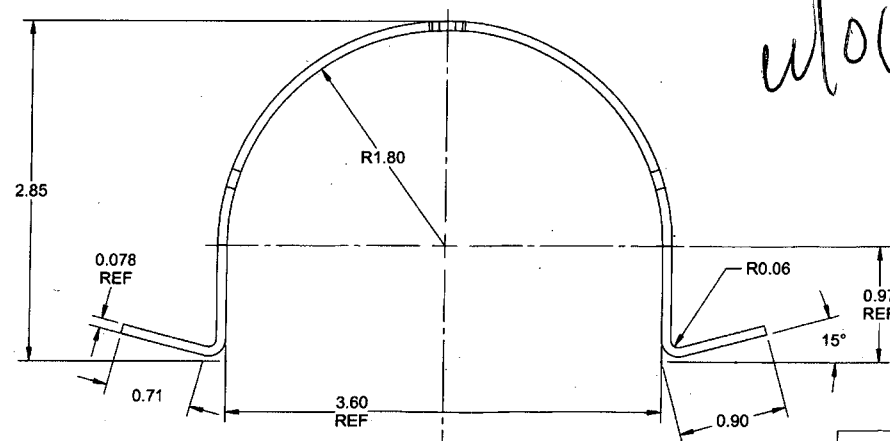
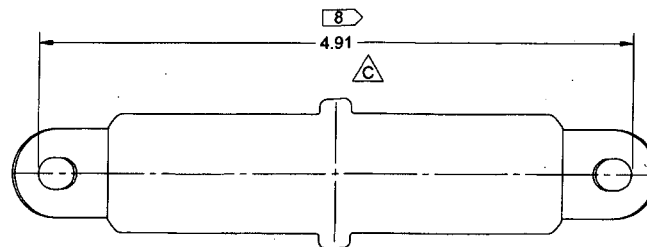
M126075

48

M129972

122

126075



w/oc 3210

RELEASED

2015 MAR 30
A.P. ECU 15-535

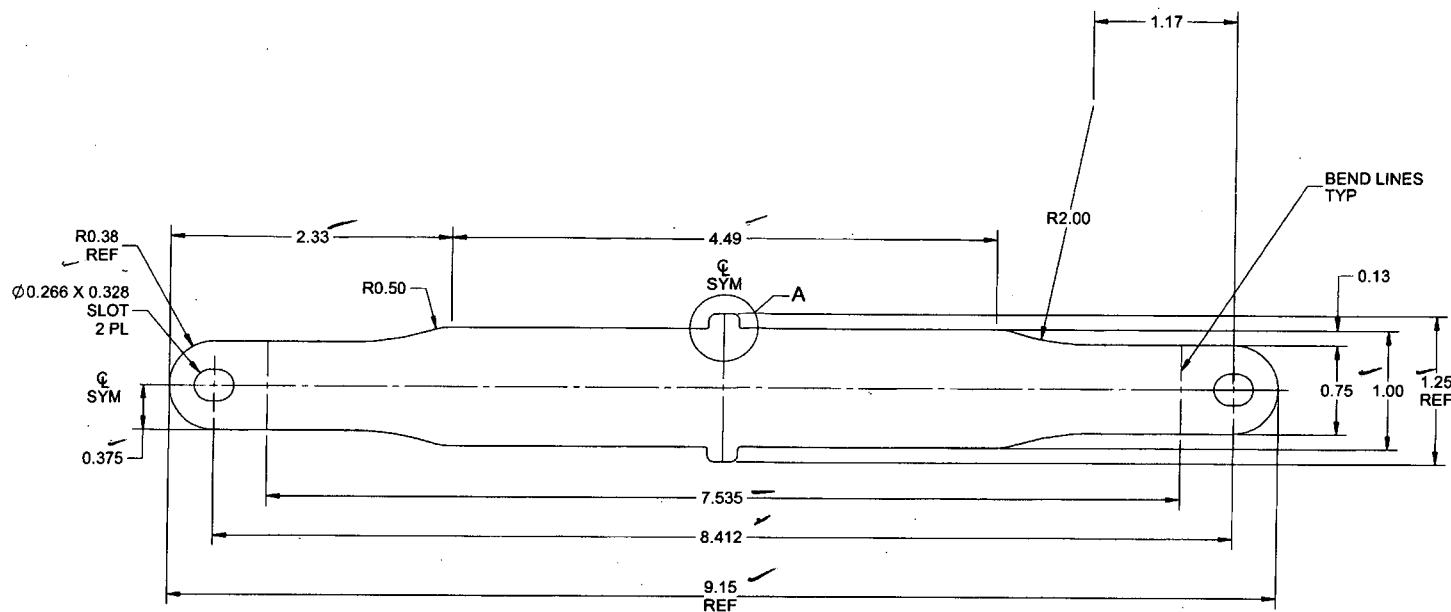
D4799-1 CLAMP



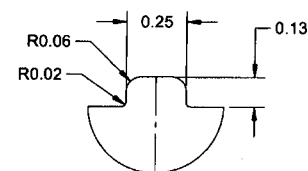
- NOTES:**
- 1) MATERIAL: MAKE FROM D4799-1F
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 0.02 lbs
 - 8) DIMENSIONED FROM BOTTOM SURFACE OF CLAMP
 - 9) NON-DIMENSIONED FEATURES CONTROLLED BY CAD FILE "D4799-1F-RevC.DXF"

C	ADD CUSHION RETENTION FEATURES. REPLACE HOLES WITH SLOTS. 2.85 WAS 2.80. REASON PAR 14-331, NCR 14-3521; ZND5-1, A5-1, A8-1, B6-2, B2-2	VS	14.10.01
B	DECREASE LENGTH FROM 9.53 TO 9.16, ZN C5-1	DC	13.05.07
A	NEW ISSUE	DC	13.03.21
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	DD	D4799	SHEET 1 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CLAMP	NTS
DATE	14.10.01	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED



D4799-1F CLAMP FLAT PATTERN



DETAIL A

RELEASED

2015 MAR 30
A.P. ECN 15-535

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET
ANNEALED 2B FINISH, 14 GAUGE (0.078 THICK)
PER AMS 5513 (304) OR 5524 (316)
OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S14GA
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.02 lbs
 - 8) NON-DIMENSIONED FEATURES CONTROLLED BY CAD FILE "D4799-1F-RevC.DXF"

APPROVED

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	DD	D4799	SHEET 2 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CLAMP	NTS
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